

# Work Order ID 60903

August 3, 2010 9:55:33 AM



Page 1

Item ID: D2933-2

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle RH In, 206

Start Date: 8/02/10 Start Qty: 4.00



Cust Item ID:

Required Date: 8/06/10 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: *u*

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool # Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D2933

Rev C

100

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

*K.A 10/08/01*

4

Ø

HAAS CNC vertical machine #1

Program part number and batch number. ☐ 1-Inspect part number and batch number are programmed correctly. ☐ 2-Machine Step No 1 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet ☐ 3-Machine Step No 2 of Folio and visually inspect as per

110

0.00



CONVENTIONAL MILLING MACHINE

Mill Conv

Memo

0.00

*8/10/08/05*

4

Ø

Conventional Milling Machine

Machine Keyway and inspect per attached dimension sheet

120

0.00



QC1- Inspect dimensions to dimension sheet

QC

Memo

0.00

*K.A 10/08/01*

4

Ø

Quality Control

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 60903

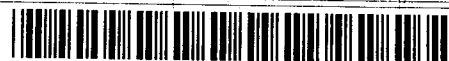
August 3, 2010 9:55:33 AM



Page 2

Item ID: D2933-2

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Setup Start



Revision ID:

Item Name: Saddle RH In, 206

Stop



Start Date: 8/02/10 Start Qty: 4.00



Cust Item ID:

Required Date: 8/06/10 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

IST 10/08/09

4 0

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

ml 10 08 09 21

150

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME: 1:00pm FINISH TIME: 1:30pm OVEN TEMPERATURE: 320°F

1115291 10/08/10

4 0

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 60903**

August 3, 2010 9:55:34 AM



Page 3

Item ID: D2933-2

Accept



Setup Start



Revision ID:

Item Name: Saddle RH In, 206

Stop



Start Date: 8/02/10 Start Qty: 4.00



Required Date: 8/06/10 Req'd Qty: 4.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool # Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

m 10 08 10 (21)

170

Identify as per dwg &amp; Stock Location: 428

0.00



Packaging

Memo

0.00

Packaging

10/8/10 SP (40)

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/08/11 J  
mr  
10-8-11

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

# Picklist Print

August 3, 2010 9:55:31 AM

Page 1

Work Order ID: 60903



Parent Item: D2933-2



Parent Item Name: Saddle RH In, 206

Start Date: 8/02/10

Required Date: 8/06/10

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP: B 00.06.26 New DWG rev (mpp 2069) EC  
IPP Rev: C As per Rev C 07-03-19 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D6101-001

Manufactured

No

100

Each

57.0000

1

4



Saddle Billet



Location

Loc Qty

Loc Code

MAT

40

46409

40

MAT40

17

46409

17

4.000

K.A 10/08/01

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 60903
<b>Description:</b> 206 Saddle, Inboard, Right side		<b>Part Number:</b> D2933-2
<b>Inspection Dwg:</b> D2933 Rev. C		<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2933 Rev. C and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		0.126	0.126	0.126	0.126		
B	0.100	0.140		0.126	0.126	0.126	0.126		Deep throat mic / 118-120
C	0.100	0.140		0.115	0.115	0.115	0.115		" "
D	0.210	0.230		0.224	0.224	0.224	0.224		" "
E	1.245	1.255		1.250	1.250	1.250	1.250		" "
F	1.245	1.255		1.250	1.250	1.250	1.250		vern / G.A-01
G	2.495	2.505		2.500	2.500	2.500	2.500		" "
H	0.510	0.515		0.510	0.510	0.510	0.510		" "
I	1.572	1.582		1.577	1.577	1.577	1.577		mic / 12
J	2.495	2.505		2.500	2.500	2.500	2.500		" "
K	0.257	0.262		0.259	0.259	0.259	0.259		" "
L	0.312	0.317		0.314	0.314	0.314	0.314		" "
M	0.235	0.240		0.239	0.239	0.239	0.239		" "
N	0.100	0.140		0.109	0.109	0.109	0.109		mic / 5704
O	0.540	0.560		0.550	0.550	0.550	0.550		mic / G.A-03
P	0.490	0.510		0.497	0.493	0.497	0.494		vern / G.A-01
Q	3.715	3.725		3.720	3.720	3.720	3.720		" "
R	2.470	2.510		2.495	2.495	2.495	2.495		" "
S	0.240	0.270		0.254	0.254	0.254	0.254		" "
T	0.100	0.180		0.130	0.130	0.130	0.130		" "
U	1.625	1.635		1.630	1.630	1.630	1.630		" "
V	1.362	1.372		1.367	1.367	1.367	1.367		" "
W	0.316	0.321		0.316	0.316	0.316	0.316		" "
X	1.125	1.145		1.136	1.136	1.136	1.136		" "
Y	1.565	1.585	DT8695 A/B	1.576	1.576	1.576	1.576		HAAS DIAL INDICATOR
Z	-0.178	-0.198		0.188	0.188	0.188	0.188		HAAS3/DIAL INDICATOR
AA									Rad gage
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: H.A.	Audited by: DJP
Date: 10/08/01, 0/08/05	Date: 10/08/09

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	

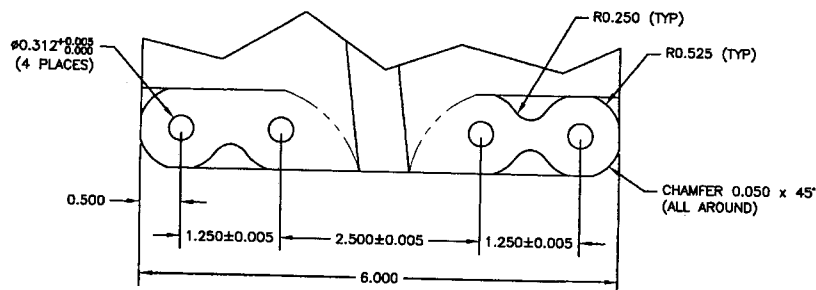
W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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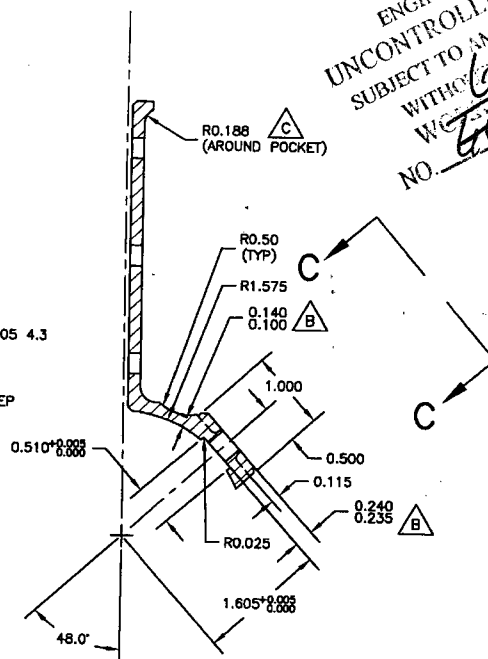


VIEW C-C

D2933-1 LH SADDLE (SHOWN)  
D2933-2 RH SADDLE (OPPOSITE)

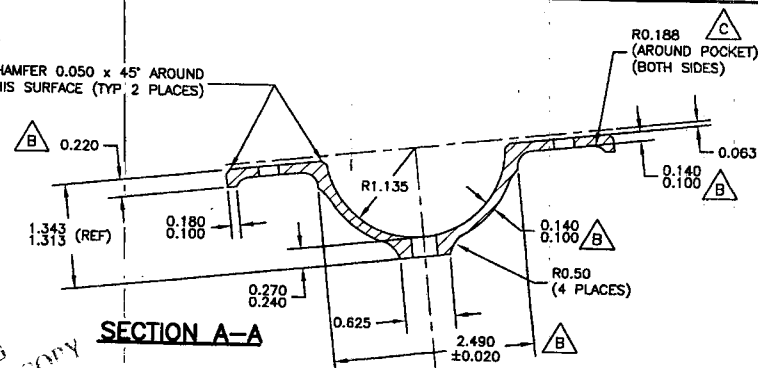
NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)  
(MAKE FROM D6101-001 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP

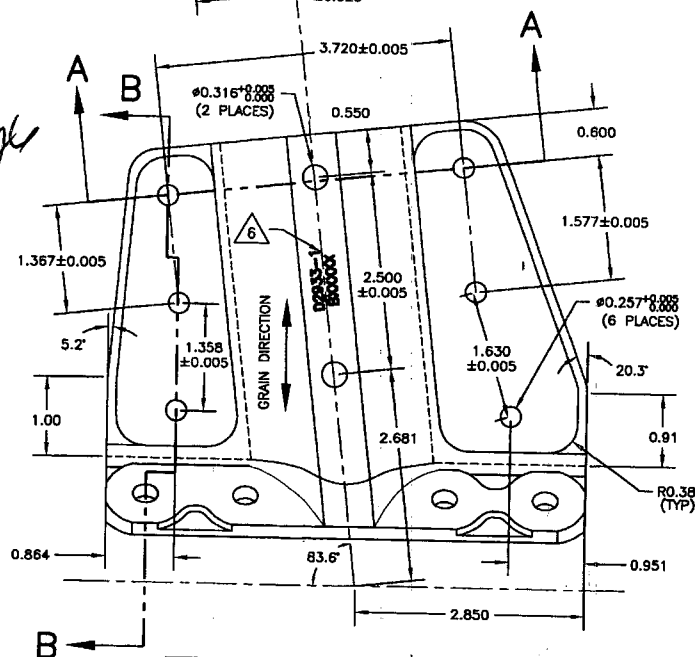


SECTION B-B

CHAMFER 0.050 x 45° AROUND  
THIS SURFACE (TYP 2 PLACES)



SECTION A-A



C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED GEOMETRY AND MATERIAL
A	99.10.29	NEW ISSUE
DESIGN	4	DRAWN BY CB
CHECKED	PH	APPROVED
DATE	06.11.09	TITLE
		SADDLE INSIDE

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DART AEROSPACE USA, INC.

DART DART AEROSPACE USA, INC.

DRAWING NO. D2933

REV. C

SHEET 1 OF 1

SCALE

2:3

RELEASED  
07.02.12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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